Monday, 3/17/2008 11:57:05 AM Kim Johnston **Process Sheet Drawing Name** : LUG BRACKET : CU-DAR001 Dart Helicopters Services / Customer Job Number : 38033 : 10010 **Estimate Number** : D27353 Part Number P.O. Number D2735 REV C **Drawing Number** : 3/17/2008 S.O. No. : This Issue : N/A : NĈ Project Number Prsht Rev. : SMALL /MED FAB : C : // **Drawing Revision** First Issue Type : 37439 Material Previous Run : 3/31/2008 Qty: 40 Um: Each **Due Date** Written By Checked & Approved By Removed from 9 Digit 1 05-10-25 JLM : Est Rev: 6 Comment Est. C 06.07.21 waterjet **Additional Product** Job Number: Description: Seq. #: 1010-1025 sheet .125 M1010S125 1.0 Comment: Qtv.: 0.1733 sf(s)/Unit Total: 6.9300 sf(s)1010-1025 sheet .125 11023 batch: 167513 WATER JET FLOW WATER JET 2.0 Comment: FLOW WATER JET 1-Cut as per Dwg D2735 188-3-25 Dwg Rev: Prog Rev: 2-Deburr if necessary INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 B8-3-24 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK BRAKE NC NC BRAKE 5.0 Comment: NC BRAKE 1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204 88 08/04/or 2-Deburr if required.

Dart Aerospace Ltd

W/O:			WORK ORDER	CHANGES				
DATE	STEP	PRO	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Category:	NCR: Ye	s No DQ	A:	Date: _	
				QA	N/C Close	d:	Date: _	
NCR:			WORK ORDER NON-CON	IFORMANCE (NO	CR)			
			Corrective Actio	n Section B				

NCR:		W	ORK ORDI	ER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B	Verification	Approval	Approval	
DATE	STEP	Section A			Sign & Date	Sign & Section C		Approval QC Inspector
						·		
•								

NOTE: Date & initial all entries

Date:

Monday, 3/17/2008 11:57:05 AM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 38033

Part Number: D27353

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

8.0 QC21



08/04/04

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 8.04.03

Dart Ae	rospace	Ltd							
W/O:			V	VORK ORDER CHANGES				 	
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			e						
Part No	:	PAR #:	Fault Ca	tegory: NO	R: Yes	No DQ	A :	Date:	
					QA: N	/C Close	d:	Date: _	
NCR:		. \	WORK OR	DER NON-CONFORMANC	E (NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B Action Description Chief Eng	Sign &	Verific Secti	cation on C	Approval Chief Eng	Approval QC Inspector
	·								
						-			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38033
Description: Lug Bracket	Part Number:	D2735-3
Inspection Dwg: D2735 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X	First Artic	ele	Proto	type	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.41	+/-0.030	:415	¥			
6.594	+/-0.010	6.590	*			
R0.63	+/-0.030	,63	¥			
1.750	+/-0.010	1,749	*			
Ø0.438	+0.006/-0.001	,439	×			
1.50	+/-0.030	1.505	*			
R1.00	+/-0.030	1,00	*			
1.50	+/-0.030	1.509	*			
0.125	+/-0.010	,118	*			
,				<u>'</u>		
	<u>.</u>					

Measured by:	HB.	Audited by:	8 (/ -	Prototype Approval:	N/A
Date:	8-3-25	Date:	8/3/25	Date:	N/A

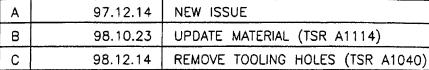
Rev	Date	Change	Revised by	Approv∉d
Α	06.08.29	New Issue	KJ/JLM O	
	•			7,4.7

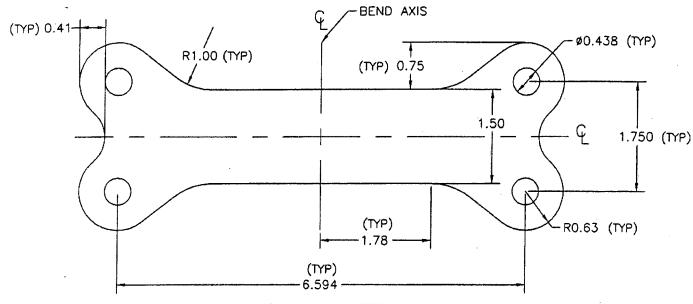




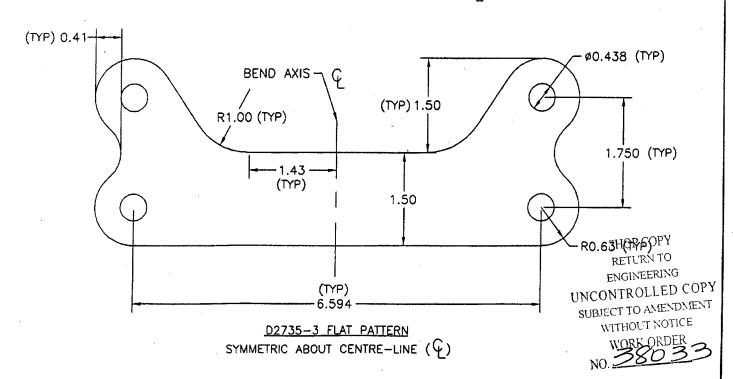
DESIG	4	ORAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANAL		
CHEC	KED A	APPROVED	DRAWING NO.	REV.	. C
	P	KE	D2735	SHEET 1 OF	2
DATE			TITLE	SC/	ALF.
98.1	2.14		LUG BRACKET		2:3
Α		97.12.14	NEW ISSUE		

RELEASED



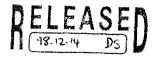


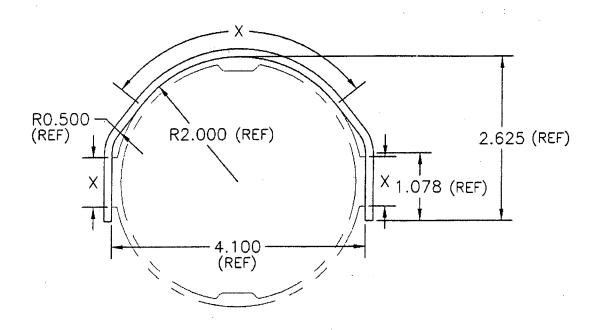
$\begin{array}{c} \underline{\text{D2735-1 FLAT PATTERN}} \\ \text{SYMMETRIC ABOUT BOTH CENTRE-LINES } (\varsigma) \end{array}$





DESIGN	DRAWN BY	DART AERO HAWKESBURY, OF	
CHECKED	APPROVED KE	DRAWING NO. D2735	REV. C SHEET 2 OF 2
DATE	!	TITLE	SCALE
98.12.14		LUG BRACKET	2:3





D2735-1 AND D2735-3 BEND DETAIL D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL

0.125 THICK (11 GAUGE)

MIN. ULTIMATE TENSILE STRENGTH = 42 ksi

MIN. YIELD TENSILE STRENGTH = 28 ksi

SHOP COPY RETURN TO

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT ALL DIMENSIONS ARE IN INCHES

WITHOUT NOTICE